

# Work Order ID 83790

Wednesday, April 25, 2012 2:43:16 PM

**\*83790\***

Ship May 1st  
Page 1

Item ID: D4464-041

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Fuel Tank Assembly

Stop **\*NS2\***

Start Date: 4/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date: 12-04-25 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4464

C

100

Weld per dwg A/R Aluminum rod Batch: 119785 0.00  
120854

**\*100\***

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

\*\*\*PURGE INSIDE OF TANK\*\*\*

1 0 12.05.04  
P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4465-041 PAR #: \_\_\_\_\_ Fault Category: Large FAB / welding NCR: (Yes) No DQA: [Signature] Date: 12/05/28  
 Resolution: Re work Disposition: Re work QA: N/C Closed: [Signature] Date: 12/5/28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/5/28	100	while welding the tank a piece of tungsten touched the weld from the torch and removed it sold in to		<sup>parts</sup> Cut + Remove Bottom of tank. Scrap + Replace D4463-B B <u>83831</u> D4425-3 B <u>83826</u> D4125-1 B <u>83825</u>	 12.05.15		 12/05.15	
		the tank. while remove the tungsten welder. ground and shut out the base of the tank. R.L. Hammer error	12.05.15 OS1 042 + ATTACHED EMAIL FROM D.S.	D 3999-9 B <u>82545</u> Re weld as per 057004 A/R <u>119785</u> <u>120834</u> as per email from DS to MB & Hatcher	 12.05.15		OS1042 + ATTACHED EMAIL FROM DS.	

NOTE: Date &amp; initial all entries

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**\*83790\***

Page 2

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Start Date: 4/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

Memo

0.00

Quality Control

1 0 BE12-05-11

120

Weld per dwg A/R Aluminum rod Batch: 119735 0.00

120854

**\*120\***

Large Fab

Memo

0.00

Large Fab

1-Weld top D4463-1

\*\*\*PURGE INSIDE OF TANK\*\*\*

12.05.14

123

QC5- Inspect part completeness to step on W/O 0.00

0.00

**\*123\***

QC

Memo

0.00

Quality Control\*

\*\*\*Pressure Test as per dwg D4464\*\*\*

-Filled with water checked with Talc. powder

5/2/16

12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 83790****\*83790\***

Page 3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Start Date: 4/25/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*140\***

QC

Memo

0.00

Quality Control

1 0 BE 12/05/15

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

1 7/16 12-5-16

160

QC7-Inspect Chemical Conversion Coat

0.00

**\*160\***

QC

Memo

0.00

Quality Control

1 0 BP 12-5-16

W/O: 1		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*83790\*

Page 4

Wednesday, April 25, 2012 2:43:16 PM

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

0.00

\*170\*

Powdercoat

Memo

0.00

Powder Coating

\*\*\*Mask prior to powdercoat\*\*\*

POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3

Start Time: 1-30

Oven Temperature: 320°F

Finish Time: 2-00

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Memo

0.00

Quality Control

190

0.00

\*190\*

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and for D4577-041/-3/-5 access panels install with proseal 890

A/R proseal 890 Batch:

M121287

M121710

1X ~~✓~~ 12/05/16

1X BL 125-16.

1X 12/05/17

P20

M118533

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
1205.17 <del>051042</del>	190	AN3H5A BOLT TOO SHORT. RC DESIGN	1205.17 051042	SUBSTITUTE NAS 1149 D0363J, QTY (5) W/ NAS 1149 D0372J QTY (4) NO WASHER AT LOCATION OF GRINDING TAG.	12/05/17		1205.17 051042	

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Wednesday, April 25, 2012 2:43:16 PM

**\*83790\***

Page 5

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**\*N900040100\***

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Revision ID:

Item Name: Fuel Tank Assembly

Stop **\*NS2\***

Start Date: 4/25/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Quality Control

Memo

0.00

*tested to 4.5 psi with full tank of water 12-05-17*

*8, 12/05/17*

*(A)*

210

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*210\***

Packaging

Memo

0.00

Packaging

*PRR 84359*

*SP*

220

QC21- Final Inspection - Work Order Release

0.00

**\*220\***

QC

Quality Control

Memo

0.00

*MLJ 12/05/17*  
*ME*  
*12-05-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, April 25, 2012 2:43:14 PM

Page 1

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Parent Item Name: Fuel Tank Assembly

Start Date: 4/25/2012 Required Date: 5/4/2012  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B 12.03.08 AS PER  
DWG REV.B DD VERF:EC IPP REV:C 12.04.24 ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-5 Placard		Manufactured	No			190	Each	4.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		94							
				72611		84				72611			
				81028		10							
D3997-11 Placard		Manufactured	No			190	Each	15.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		15							
				80308		3				80308			
				82957		12							
D3997-17 Placard		Manufactured	No			190	Each	17.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		17							
				80309		5				80309			
				82958		12							
D3997-29 Placard		Manufactured	No			190	Each	18.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		18							
				80845		18				80845			
D3997-43 Placard		Manufactured	No			190	Each	15.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST141		15							
				80310		3				80310			
				82960		12							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, April 25, 2012 2:43:15 PM

Page 2

Work Order ID: 83790

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-7 Corner	Manufactured	No	100	Each	9.0000	1	1	<i>12-04-26</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA014	9				
			71695	1				
			75156	8				
D3999-9 Angle	Manufactured	No	100	Each	8.0000	1	1	<i>12-04-26</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA014	8				
			71696	1				
			82545	7				
D3999-11 Earth Tab	Manufactured	No	100	Each	2.0000	1	1	<i>12-04-26</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	8				
			WA013	-8				
			WA014	2				
			75180	2				
D4000-1 Fuel Supply Fitting	Manufactured	No	100	Each	1.0000	1	1	<i>12-05-03</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA <i>B83811</i>	1				
			80029	1				
D4000-5 Fuel Tank Vent Fitting	Manufactured	No	100	Each	1.0000	1	1	<i>12-05-03</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA013 <i>B83813</i>	1				
			80030	1				

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, April 25, 2012 2:43:15 PM

Page 3

Work Order ID: 83790

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-9  
Grommet

Manufactured No

100 Each 6.0000

3

3

12.04.26

Location

Loc Qty

Loc Code

WA013

6

78379

6

3

D4000-045  
Fuel Pickup Fitting Assembly

Manufactured No

100 Each 7.0000

1

1

12.04.26

Location

Loc Qty

Loc Code

WA

1

81071

1

WA013

5

72078

1

82696

4

WA014

1

71669

1

1

D4008-11  
Hinge Half

Manufactured No

100 Each 12.0000

1

1

12.04.26

Location

Loc Qty

Loc Code

WA

12

80037

4

80838

8

1

D4008-041  
Fuel Filler Splash Guard Assembly

Manufactured No

190 Each 3.0000

1

1

12.04.26

Location

Loc Qty

Loc Code

ST142

3

78910

3

78910

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 3

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Wednesday, April 25, 2012 2:43:15 PM

Page 4

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Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3  
Cap and Flange

Manufactured No

190 Each 10.0000

1 1

*12.06.26*

Location

Loc Qty

Loc Code

ST084

6

81898

6

ST110

1

73514

1

WA

3

80032

3

D4025-5  
Fuel Quantity Sender

Manufactured No

190 Each 8.0000

1 1

*E*

Location

Loc Qty

Loc Code

ST141a

8

76894

2

81899

6

*81899*

D4057-1  
Retaining Ring

Manufactured No

100 Each 12.0000

3 3

*12.04.26*

Location

Loc Qty

Loc Code

WA013

12

71166

3

81889

9

*3*

D4062-041  
Tank Support Assembly

Manufactured No

190 Each 0.0000

1 1

*12.05.04*

D4124-1

Tab

Manufactured No

100 Each 7.0000

4 4

*12.05.02*

Location

Loc Qty

Loc Code

WA

7

76895

7

*3*

D4125-1

Sump

Manufactured No

100 Each 1.0000

1 1

*12.05.02*

Location

Loc Qty

Loc Code

WA

1

81151

1

*1*

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 4

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Wednesday, April 25, 2012 2:43:15 PM

Page 5

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Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

D4125-3 Manufactured No 100 Each 1.0000 1 1

End

Location	Loc Qty	Loc Code
WA - 383826	1	
81152	1	

D4404-3 Manufactured No 100 Each 5.0000 1 1

Cushion, Side

Location	Loc Qty	Loc Code
ST242A	5	
76898	5	

D4404-5 Manufactured No 100 Each 10.0000 4 4

Cushion, Fwd

Location	Loc Qty	Loc Code
ST242A	10	
76899	1	
80753	9	

\* D4462-1 Manufactured No 100 Each 0.0000 1 1

Baffle

\* D4462-3 Manufactured No 100 Each 0.0000 1 1

Baffle

\* D4463-041 Manufactured No 120 Each 0.0000 1 1

Tank Top Assembly

\* D4463-3 Manufactured No 100 Each 0.0000 1 1

Tank Aft End

D4463-5 ~~4555~~ 383834 Manufactured No 100 Each 0.0000 1 1

Tank Upper Cut Out

\* D4463-7 Manufactured No 100 Each 0.0000 1 1

Tank Fwd End

\* D4463-9 Manufactured No 100 Each 0.0000 1 1

Tank Back

D4463-11 Manufactured No 100 Each 0.0000 1 1

Tank Front

Location	Loc Qty	Loc Code
<del>383836</del> 383830	1	

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 5

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Wednesday, April 25, 2012 2:43:15 PM

Page 6

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Parent Item: D4464-041  
Parent Item Name: Fuel Tank Assembly

Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-13 Manufactured No 190 Each 2.0000  
Tank Bottom

1 1 *12.04.26*

Location Loc Qty Loc Code

WA *B83831* 2

AN3H5A Purchased No 190 Each 47.0000  
Bolt

*1*  
5 5 *✓*

Location Loc Qty Loc Code

ST351 47

118112 1

120693 46

MS21042L3 Purchased No 190 Each 3,266.0000  
Nut

*120693*  
4 4 *✓*

Location Loc Qty Loc Code

ST300 3266

117441 16

117885 32

118451 5

118927 3

119017 1196

119075 158

121349 856

121444 1000

~~MS35206-200~~ *A23-6A* Purchased No 190 Each 96.0000  
Screw *nut*

*121349*  
4 4 *✓*

Location Loc Qty Loc Code

ST294 96

119850 96

*A205.17*  
*Q21042*

*1120644*

*119850*

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, April 25, 2012 2:43:15 PM

Page 7

Work Order ID: 83790  
 Parent Item: D4464-041  
 Parent Item Name: Fuel Tank Assembly  
 NAS1149D0363J  
 Washer

Start Date: 4/25/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

Purchased

No

190

Each

1,823.0000

37

37

## Location

## Loc Qty

## Loc Code

ST298

1823

117601

61

118077

1

118612

18

119537

33

120142

55

120308

46

120644

241

121243

1368

121243

AN3-4A

Purchased

No

190

Each

716.0000

24

24

Bolt

## Location

## Loc Qty

## Loc Code

ST350

716

102832

88

104291

4

104625

246

117317

98

120308

80

120770

200

104625

D4577-1

Manufactured

No

190

Each

0.0000

1

1

Rear Access Panel

D4577-3

Manufactured

No

190

Each

0.0000

1

1

Middle Access Panel

D4577-041

Manufactured

No

190

Each

0.0000

1

1

Fwd Access Panel Assembly

B 83839

B 83840

B 83838

M119719

SB 12605/40

SB 12605/40

SB 12605/40

5

NAS 1149D03325

12 05-16

Wednesday, April 25, 2012 2:43:15 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	<del>MS36207-200</del>	SCREW <i>AN3-6A BOLT</i>
41	37	NAS1149D0363J	WASHER.

△

△

△

*12.03.17*  
*08.09.12*

*#83790*

RELEASED  
2012-04-24

C	UPDATED -041 WITH RE-DESIGNED D4463-11/-13 REV. C PARTS, ZN B6-2, UPDATED -041 WITH RE-DESIGNED D4577-041/-3/-5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13, ADDED D4577-041/-1/-5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE, REF PAR11-117 & CAR 11-54.	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BC</i>	<b>D4464</b>	SHEET 1 OF 5
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	<b>TANK ASSEMBLY</b>	NTS
DATE	<b>12.03.27</b>	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

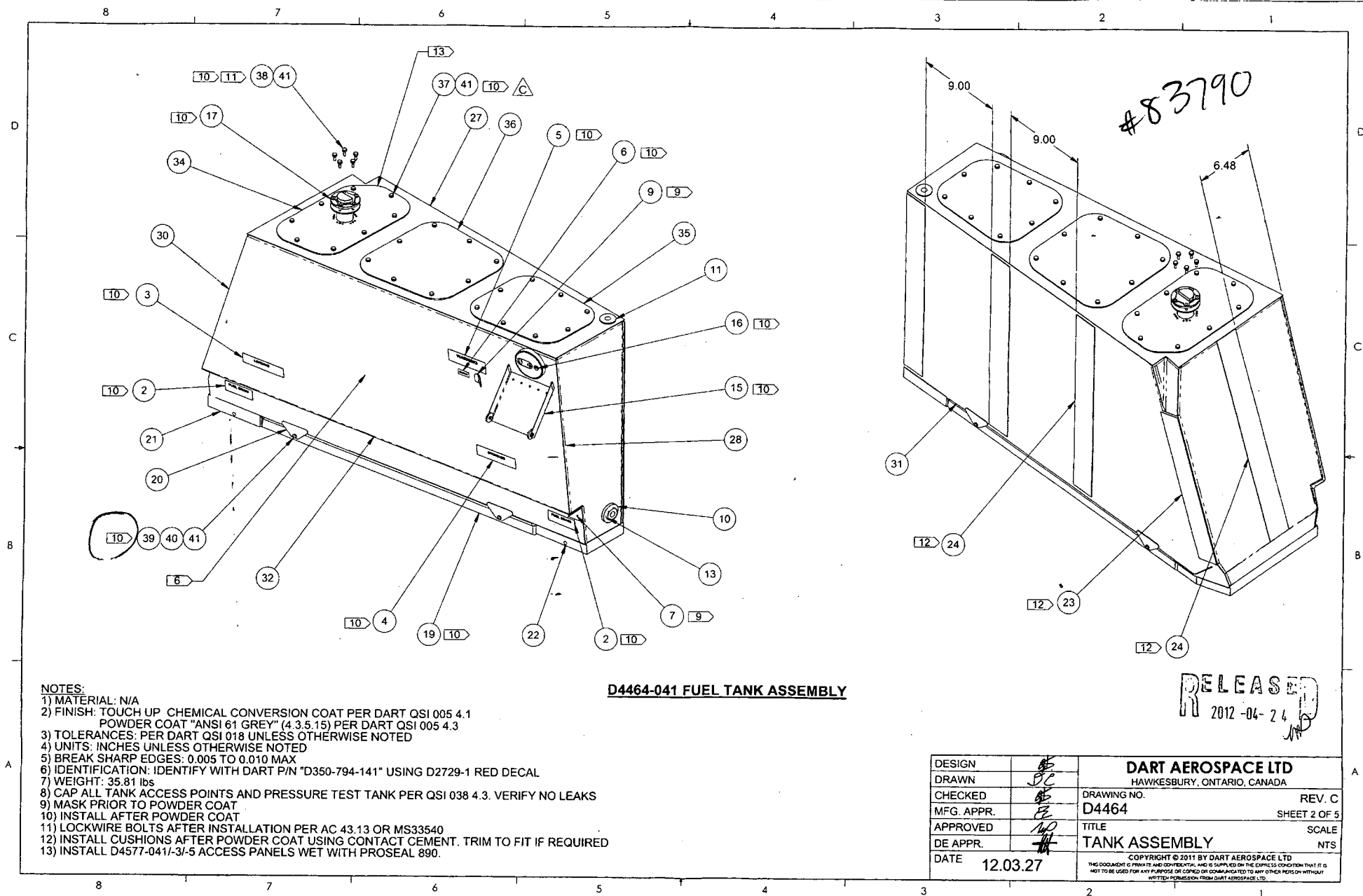
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

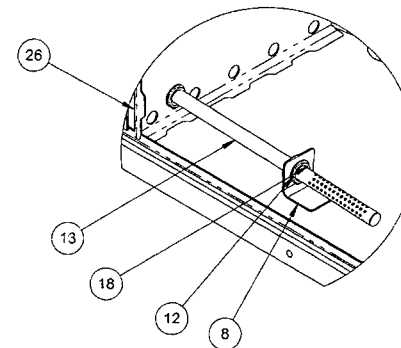
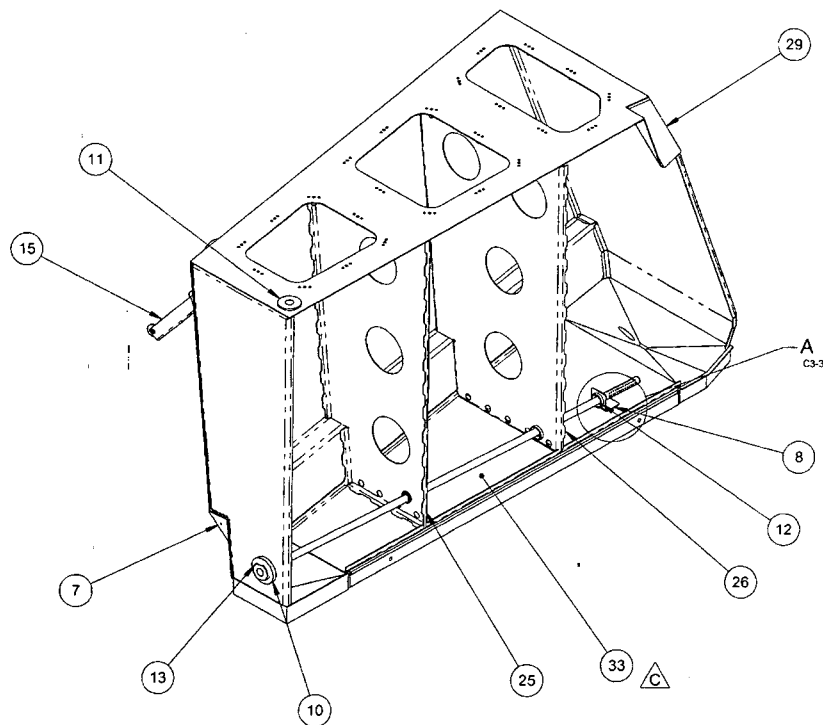
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**NOTE:** Date & initial all entries



**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-3

**D4464-041 FUEL TANK ASSEMBLY**  
**D4463-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO. <b>D4464</b>	REV. C
MFG. APPR.	<i>SC</i>	SHEET 3 OF 5	
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	<b>TANK ASSEMBLY</b>	NTS
DATE	<b>12.03.27</b>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

#83790

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2012-04-24  
JHD

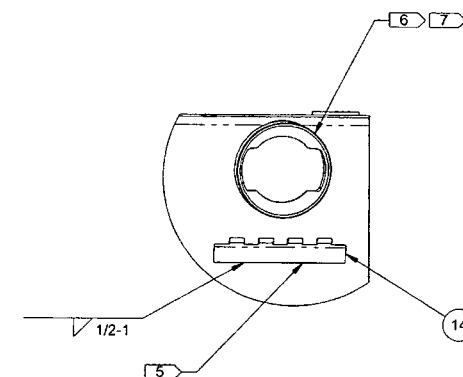
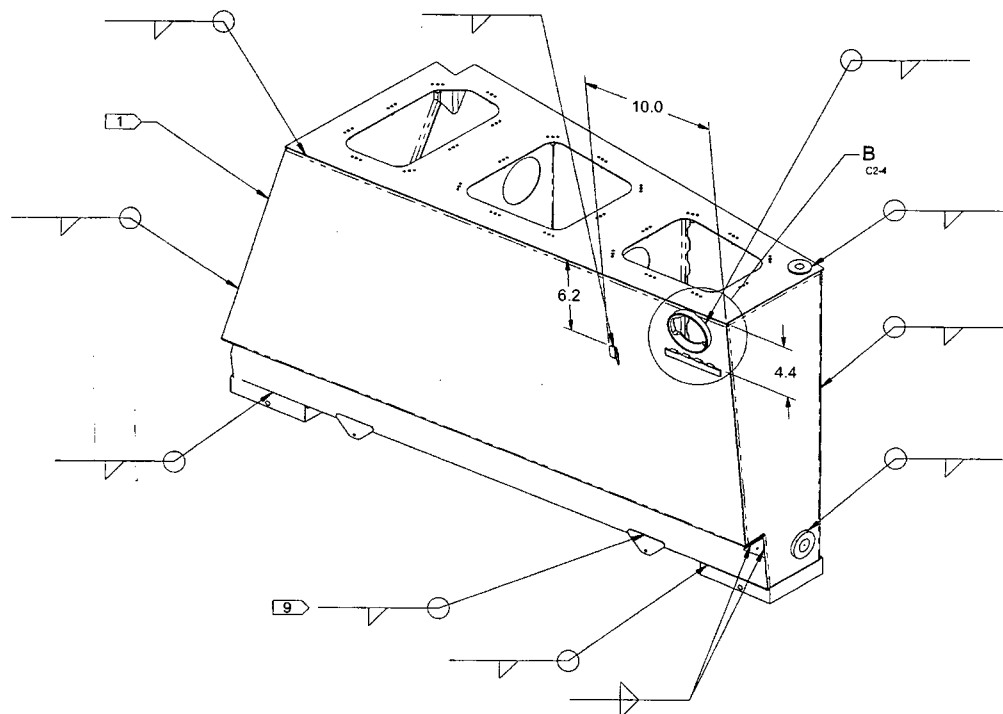
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**DETAIL B**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

C2-4

**D4464-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - ALL SWarf REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING

**RELEASED**  
2012-04-24

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO. <b>D4464</b>	REV. C
MFG. APPR.	<i>BE</i>	SHEET 4 OF 5	
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	<b>TANK ASSEMBLY</b>	NTS
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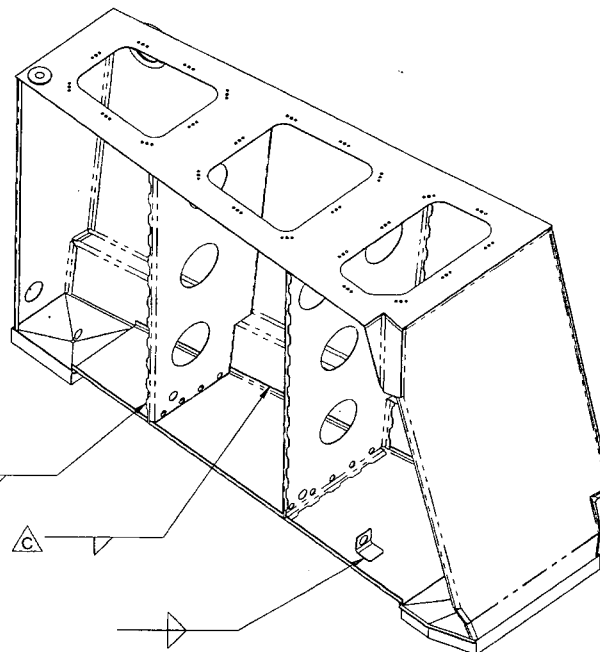
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





WELD ALL TABS

**D4464-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

483790

11.11.13  
2012-04-24

DESIGN	JE	<b>DART AEROSPACE LTD</b>	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. C
MFG. APPR.	JE	D4464	SHEET 5 OF 5
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	TANK ASSEMBLY	NTS
DATE	12.03.27	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Linda Lacelle

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** May-04-12 6:08 PM  
**To:** 'Linda Lacelle'; 'Marc Bellavance'  
**Cc:** 'Downing, Eric'; 'Duval, David'; 'Smith, Pat'  
**Subject:** RE: D4464-041 Fuel Tank

Agreed ... I think Option 3 is the way to go on this one.

David

---

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** May-04-12 12:36 PM  
**To:** 'Marc Bellavance'; 'Shepherd, David'  
**Cc:** 'Downing, Eric'; 'Duval, David'; 'Smith, Pat'  
**Subject:** RE: D4464-041 Fuel Tank

I think we should go with # 3

L

---

**From:** Marc Bellavance [<mailto:mbellavance@dartaero.com>]  
**Sent:** May-04-12 2:31 PM  
**To:** Shepherd, David  
**Cc:** Downing, Eric; Duval, David; Lacelle, Linda; Smith, Pat  
**Subject:** D4464-041 Fuel Tank  
**Importance:** High

David,

We currently have a fuel tank in production and there is an issue... The bottom of the tank was punctured while welding a bracket on the bottom inside surface. It's ok from the inside but the outside requires quite a bit of welding to rebuild the sheet metal as shown in the photo.

In talking with the guys, we've come up with 4 scenarios as follows:

1. Rework the problematic area while keeping the formation of pin holes to a minimum;
2. The bottom sheet could be cut between the 2 sediment bowls. A new sheet would be trimmed to fit and welded in place;
3. The bottom of the tank is only tacked in place so PatE could remove the bottom sheet and the 2 sediment bowls and then replace with new parts;
4. Scraping the tank.

We would like to avoid scrapping the tank since it is scheduled to ship on Wednesday and we need another one ASAP for Peak Aviation. But if you think this has to be done then so be it...

Please advise.

Thanks,



**Marc Bellavance**

*Technical/Shop Support*

T. 613-632-5200 C. 613-676-0992 F. 613-632-9311

1270 Aberdeen Street, Hawkesbury, Ontario, Canada, K6A 2K7

**Product Documentation: Verify Revision Status/Download [HERE!](#)**

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